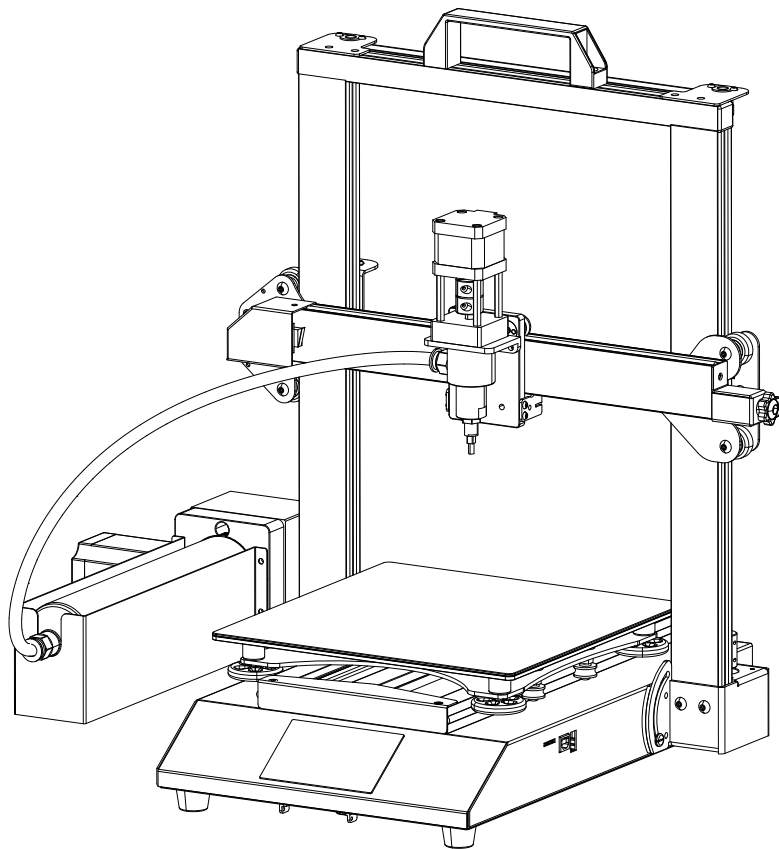


TRONXY

MOORE 2 PRO

Clay 3D printer User Manual

陶泥3D打印机使用说明书





When unpacking, please check the packing list to ensure that no parts are lost or damaged. If any, please contact our after-sales personnel immediately and we will reissue them for you in the shortest time.

开箱时,请对照装箱清单,确保无零件的丢失及损坏,如有发生,请立即联系我们的售后人员,我们会在最短时间内为您补发。



Please use the machine in a ventilated, dry, clean and flat environment.

请在通风、干燥、清洁、平坦的环境中使用机器。



The machine contains high-speed moving parts. Children are not allowed to use the printer alone. It is not recommended to use this 3D printer when unattended.

该机器包含高速运动部件,儿童不得单独使用打印机;无人看管情况下,不建议运行 3D 打印机。



The recommended room temperature for 3D printers is 8°C-40°C, and the humidity is 20% - 80%. If used outside this temperature and humidity range, it may lead to a bad printing effect.

3D 打印机的使用环境温度建议为 8°C-40°C,湿度为 20%-80%,在此范围之外使用,可能带来不良的打印效果。



In an emergency, you can turn off the power directly.

在紧急情况下,可直接关闭电源。



If the user's unauthorized modification or disassembly causes damage to the core components of the machine, the situation is not covered by the warranty.

如果用户擅自改装或者拆卸导致机器的核心部件损坏,则该情况不在保修范围内。



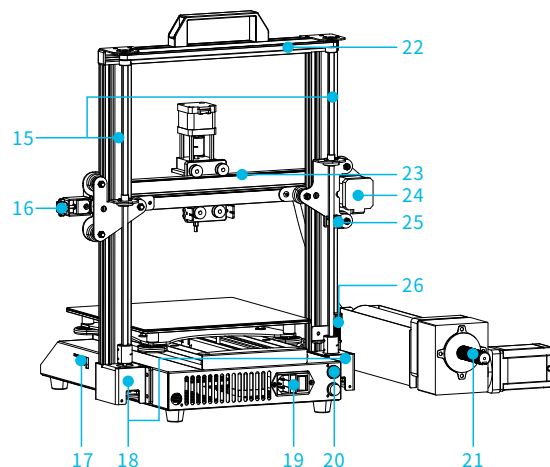
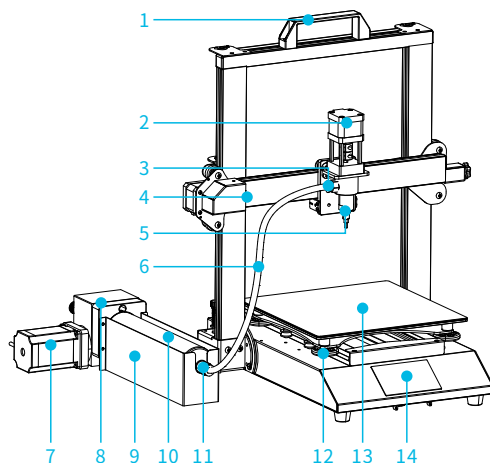
Video, software and other related information are stored in the TF card, please check.

视频,软件等相关信息存储在TF卡中,请查看。

Directory 目录

Introduction	1	设备简介	1
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Introduction 设备简介



- | | | | |
|--|---|--|---|
| 1 Handle
提手 | 8 Transmission
变速器 | 15 Z-axis screw rod
Z轴丝杆 | 22 Closed loop timing belt
闭环同步带 |
| 2 Print head motor
打印头电机 | 9 Barrel support plate
料筒支撑板 | 16 X axis belt adjustment knob
X轴皮带调节旋钮 | 23 X-axis guide rail
X轴导轨 |
| 3 PC10-03 pneumatic connector
PC10-03气动接头 | 10 Barrel
料筒 | 17 USB-A, USB-B and TF card sockets
USB-A、USB-B和TF卡插口 | 24 X-axis motor
X轴电机 |
| 4 X-axis limited switch
X限位开关 | 11 PC10-02 pneumatic connector
PC10-02气动接头 | 18 Z-axis motor
Z轴电机 | 25 Z-axis limit switch
Z轴限位开关 |
| 5 Print head nozzle
打印头喷嘴 | 12 Platform leveling nut
平台调平螺母 | 19 Power cord sockets and switches
电源线插口和开关 | 26 Z limit switch adjustment nut
Z限位开关调节螺母 |
| 6 Tube
料管 | 13 Printing platform
打印平台 | 20 Transmission connection port
变速器连接口 | |
| 7 57 feeding motor
57挤出电机 | 14 3.5"full color touch screen
3.5寸全彩触摸屏 | 21 Feeding screw
螺杆 | |

Parameter 设备参数

Print parameters

打印参数

Printing principle :	LDM (Liquid Deposition Molding)
打印原理	LDM (液体沉积成型)

Print volume :	255*255*260 (mm)
打印体积	

Printing accuracy :	0.3-3.0mm
打印精度	

Positioning accuracy :	X/Y: 0.00625mm, Z:0.00125mm
定位精度	

Number of printhead :	1
喷头数量	

Nozzle diameter :	1.0-3.0 mm (optional)
喷嘴直径	1.0-3.0 mm (可选)

Print speed :	10~40mm/s (20mm/s is recommended)
打印速度	10~40mm/s (建议20mm/s)

Moving speed :	60mm/s
移动速度	

Consumables :	Ceramic mud, porcelain mud, purple sand mud, etc
耗材	陶泥 瓷泥 紫砂泥等

Temperature parameter

温度参数

Ambient temperature :	8°C - 40°C
环境温度	

Software parameters

软件参数

Slicing software :	Cura
切片软件	

Input format :	.STL .OBJ
输入格式	

Output format :	Gcode
输出格式	

Connection method :	TF card, USB disk, USB cable (for skilled users)
连接方式	TF卡、U盘、USB线(适用于熟练使用者)

Power parameters

电源参数

Power input :	100V-220V AC, 50/60Hz
电源输入	

Power output :	24V/120W
电源输出	

Physical parameters

物理参数

Machine size :	410*414*510 (mm)
机器尺寸	

Machine weight :	≈10kg
机器重量	

Packing list 包装清单



1 Machine *1
机身*1

2 Print head *1
打印头*1

3 Handle *1
提手*1

4 Fiberglass board plate *2
玻纤板*2

5 Clip *4
夹子*4

6 Feed transmission *1
进料变速器*1

7 Extrusion screw *1
挤出螺杆*1

8 Piston *1
活塞*1

9 Clay *2
陶泥*2

10 PC10-02 pneumatic connector *2
PC10-02气动接头*2

11 Barrel 0.5L *2
料筒 0.5L *2

12 Barrel holder *1
料筒支撑板*1

13 Transmission connection line*1
变速器连接线*1

Packing list 包装清单

14 	15 	16 	17 	18 	19 
20 	21 	22 	23 	24 	25 
26 	27 	28 	29 	a 	b 

14 Tube *2
料管 *2

15 Stretch film *1
缠绕膜 *1

16 A box of nozzles (spare) *1
喷嘴一盒(备用) *1

17 Power cord *1
电源线 *1

18 USB cable *1
USB数据线 *1

19 Card reader and TF card *1
读卡器和TF卡 *1

20 Tie(Random color)
扎带(颜色随机)

21 PC10-03 pneumatic connector (spare) *1
PC10-03气动接头(备用) *1

22 Shovel (Random color)*1
铲刀(颜色随机)*1

23 M4 straight handle wrench *1
M4直柄扳手 *1

24 L-type wrench *5
L型扳手 *5

25 14-17 open end wrench *1
14-17开口扳手 *1

26 8-10mm open end wrench *1
8-10mm开口扳手 *1

27 6mm open end wrench *1
6mm开口扳手 *1

28 Raw material belt *1
生料带 *1

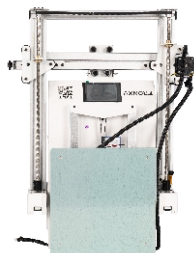
29 Sealing ring *2
密封圈 *2

a M4*10 screw
M4*10螺丝

b M4*20 screw
M4*20螺丝

Machine installation 机器安装

1. Installation of the machine 机身的安装



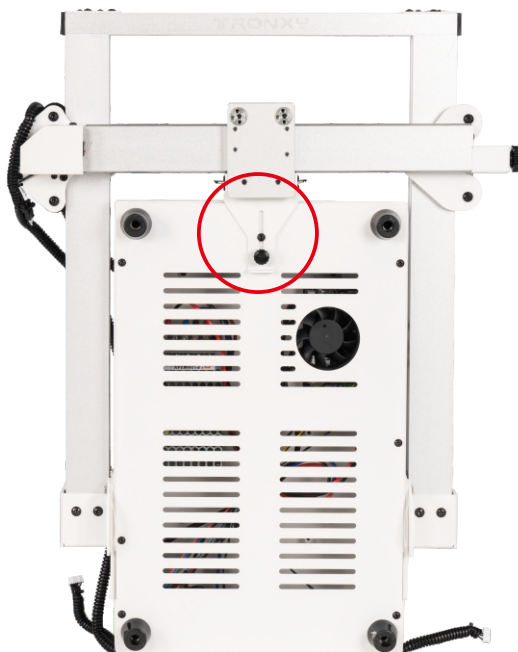
1

Machine*1
机身*1

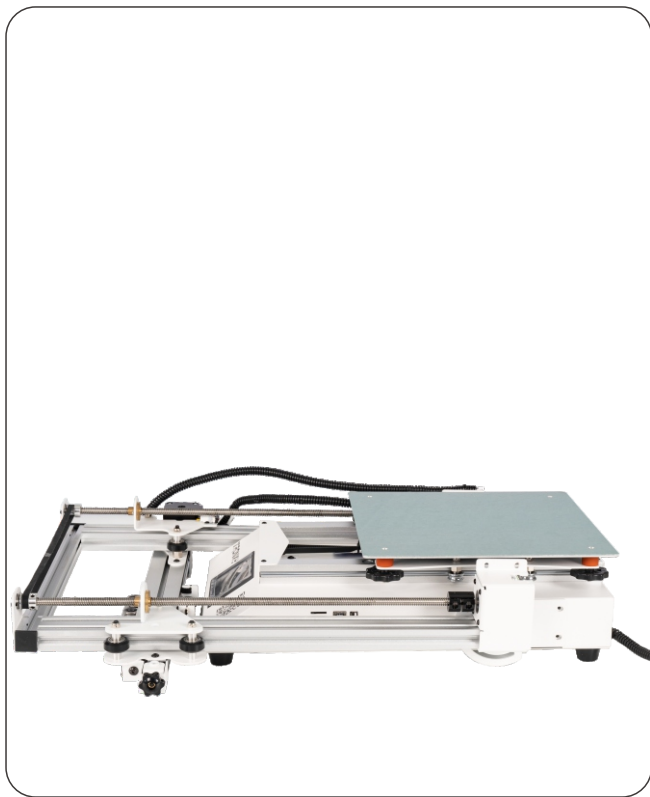


a

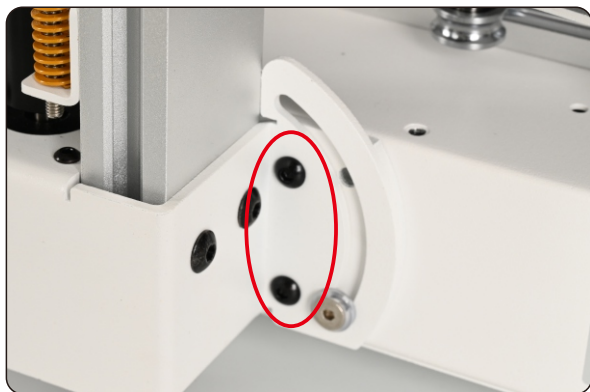
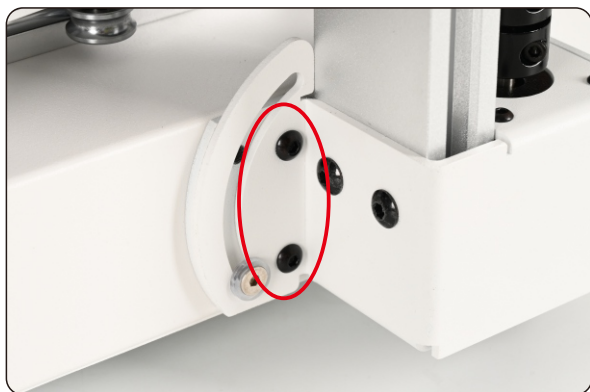
M4*10 screws *8
M4*10螺丝*8



Loosen the screws and loosen the fixing plate
拧松螺丝, 松开固定板



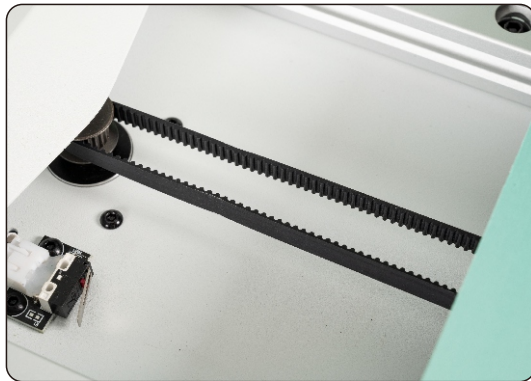
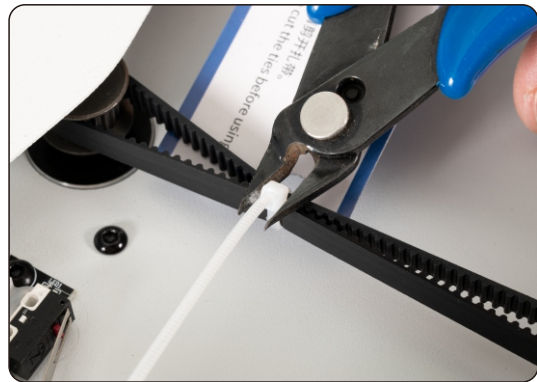
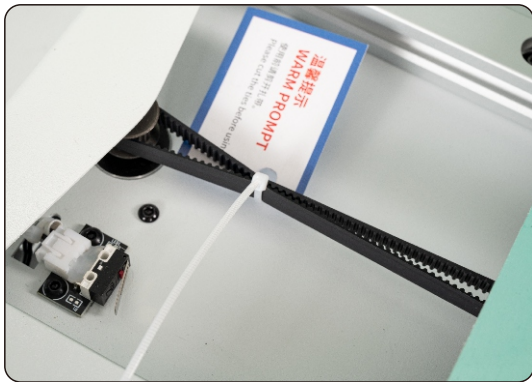
Lift up the fuselage frame
掀起机身框架



Fix the frame with 8 M4 * 10 screws
使用8颗M4*10螺丝固定框架

Machine installation 机器安装

2. Unfasten the belt under the printing platform of the base
解开底座打印平台下方的皮带



3. Installing the print head and handle 安装打印头和提手



2

Print head *1
打印头 *1



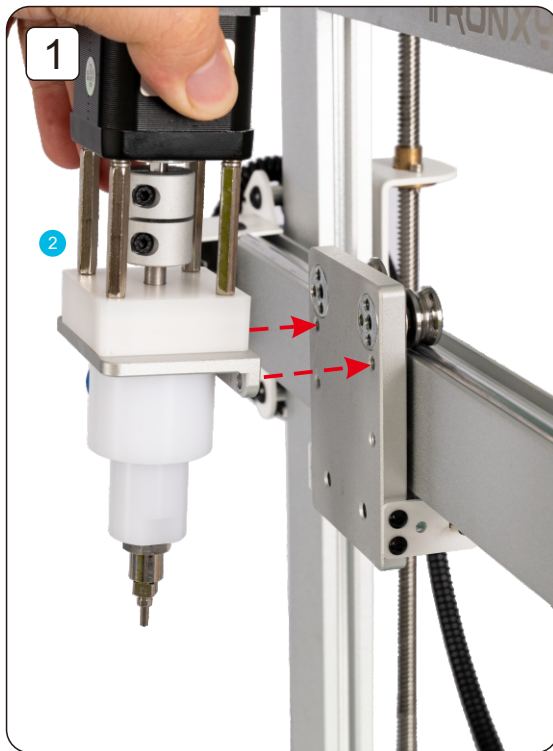
3

Handle *1
提手 *1



a

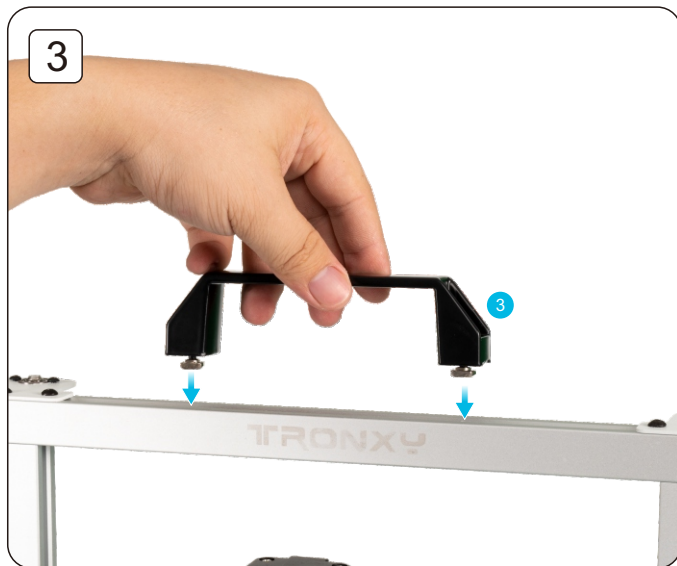
M4*10 screws *2
M4*10螺丝*2



Install the print head on the slider as shown in the figure
如图所示, 将打印头安装到滑块上



Fix the print head with 2 M4 * 10 screws
使用2颗M4*10螺丝固定打印头

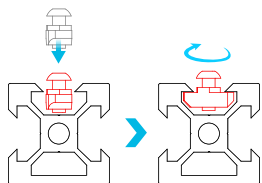


Install the handle onto the frame
将提手安装到框架上



Working principle of boat nut

船型螺母的工作原理



Loosen the boat nut on the Filament rack slightly, pay attention not to remove the nut, then put it into the groove of the aluminum profile in parallel direction, and tighten the screw clockwise quickly, so that the boat nut is stuck in the groove of the aluminum profile at 90°.

略微松开料架上的船型螺母，注意无需取下螺母，然后平行方向放入铝型材的槽内，顺时针快速拧紧螺丝，使得船型螺母90°卡在铝型材的槽内。



Tighten the screws

拧紧螺丝

4. Install fiberglass board and Z-axis limit switch 安装玻纤板和Z轴限位开关



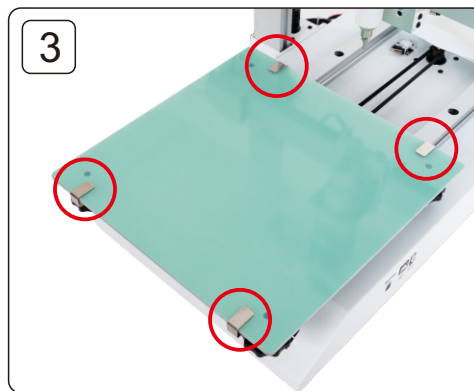
4

Fiberglass board plate*1
玻纤板 *1



5

Clip*4
夹子 *4



+



Before printing, cover the fiberglass board plate with a layer of stretch film, it can prevent the bottom of the model from cracking.

在打印之前，在玻纤板上覆盖一层缠绕膜，可以防止模型底部干裂。

5. Insert connection line 插入连接线



6

Feed transmission*1
进料变速器*1



13

Transmission
connection line*1
变速器连接线*1



Insert the right Z-motor line
插入右边Z电机线



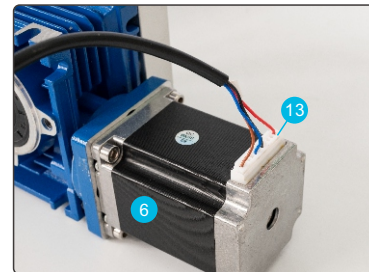
Insert the left Z-motor line
插入左边Z电机线



Insert the print head motor line
插入打印头电机线



Insert the transmission line into the machine
将变速器连接线插入机器

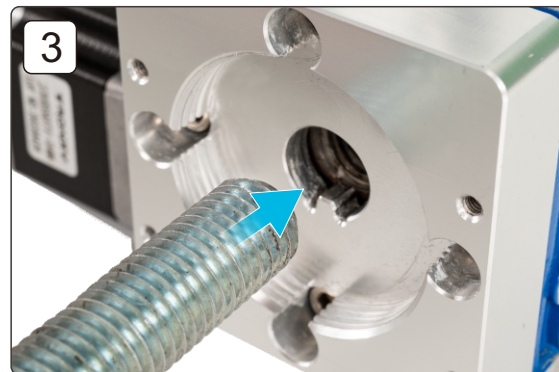
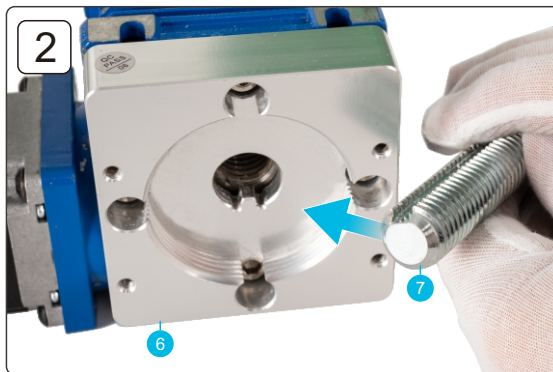


Insert the transmission connection line into
the transmission
将变速器连接线插入变速器

6. Installing the feeder 安装送料装置



Insert the power cord and turn on the switch
插入电源线, 打开开关



Insert the extrusion screw into the feed transmission at the side without screw hole
将挤出螺杆没有螺丝孔的一边, 插入进料变速器中

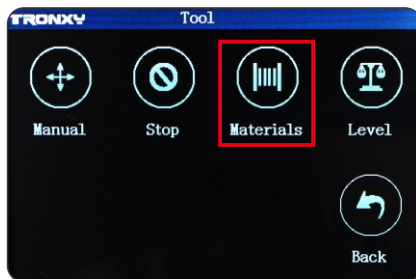
Machine installation 机器安装

4

Start the transmission and feed the screw into the transmission
启动变速器，将螺杆送入变速器中



Select "Tool"
选择“工具”



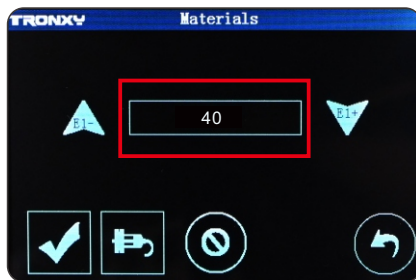
Select "Materials"
选择“材料”



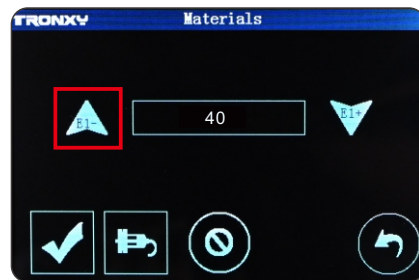
Click the icon here to switch to
"control extruder only"
点击此处图标，切换到“只控制挤出机”



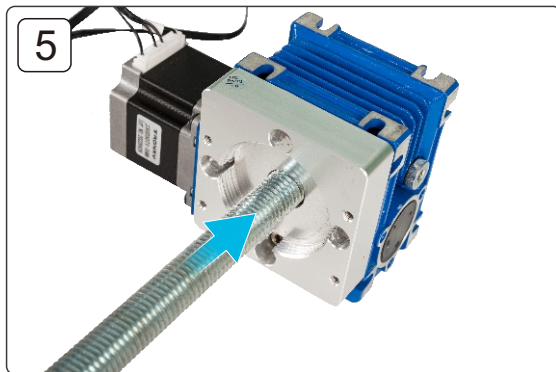
This icon indicates "control extruder only"
此图标表示“只控制挤出机”



Click "speed display box" to set the speed to 40 (maximum)
点击“速度显示框”，将速度设置为40(最大值)

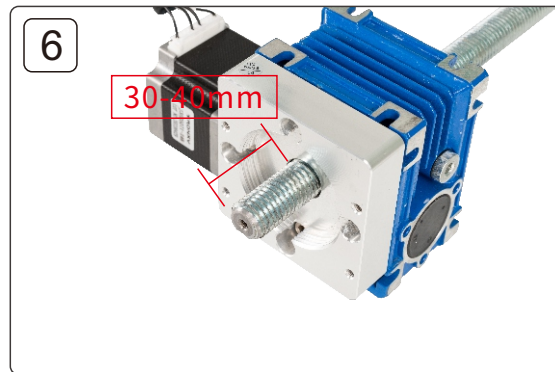


Click the "E1-" icon, at this time, the feeding
transmission will start, and the screw will be sent
to the transmission.
点击“E1-”图标，此时进料变速器会启动，
将螺杆送入变速器。



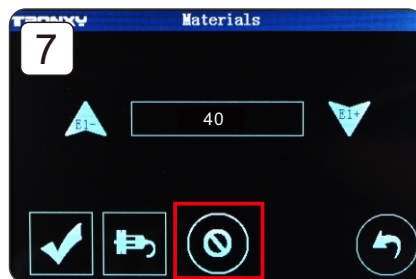
The feeding transmission is started and the screw is fed into the transmission

进料变速器启动, 将螺杆送入变速器



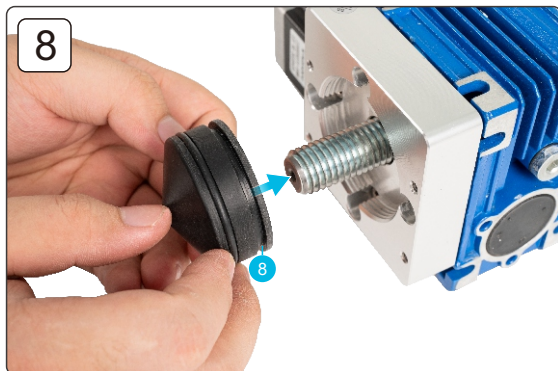
Keep the protruding length of the screw about 30-40mm to install the piston

保留螺杆凸出长度约30-40mm, 用来安装活塞

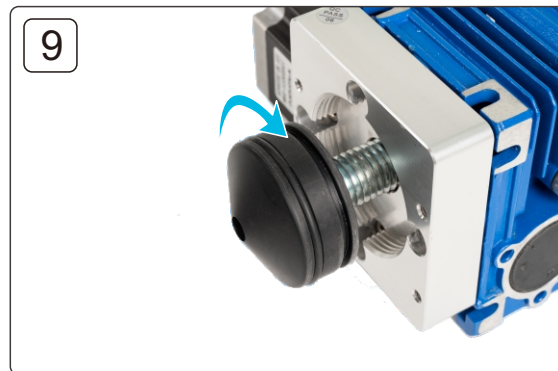


Click the "Stop" icon

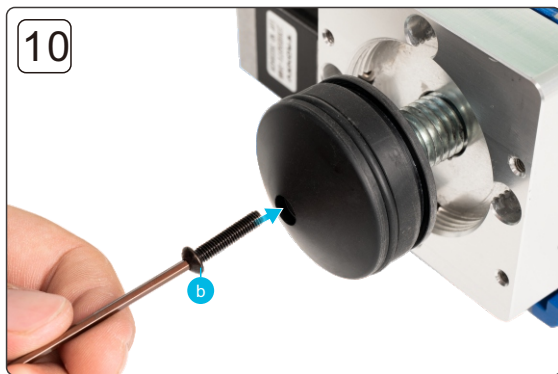
点击“停止”图标



Install the piston
安装活塞



Tighten the piston clockwise
顺时针拧紧活塞



Fix the piston with an M4*20 screw
使用一颗M4*20螺丝固定活塞



Piston installation completed
活塞安装完成



9

Clay *1
陶泥 *1



10

PC10-02 pneumatic
connector *1
PC10-02气动接头 *1



11

Barrel 0.5L *1
0.5L料筒 *1

7. Load the clay into the barrel and install the barrel 将陶泥装入料筒中, 并安装料筒

1



9

Knead the dough into a cylindrical shape slightly smaller than the material barrel

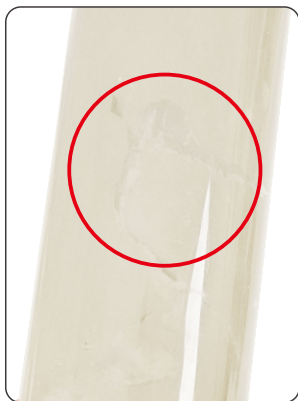
将泥团揉成比料筒略小的圆柱形



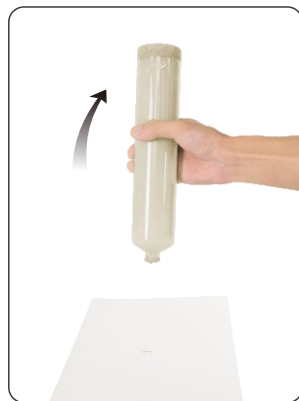
Put the clay into the barrel

将泥团放入料筒里

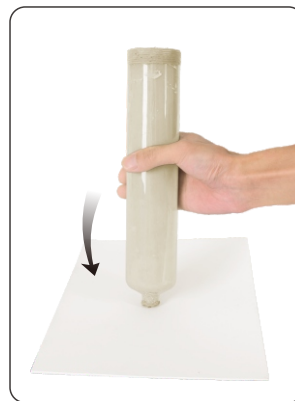
3



Bubbles were found after filling the mud
装泥后发现气泡



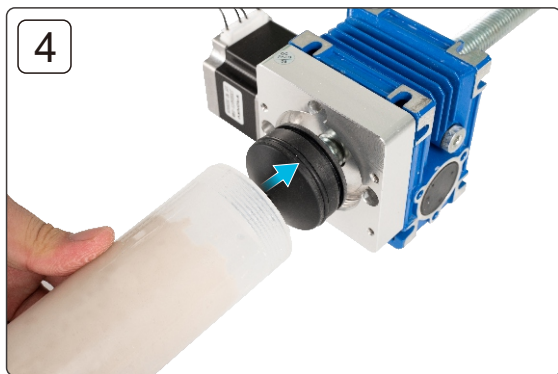
Beat the barrel up and down
上下捶打料筒



After squeezing out the bubbles
挤出气泡后

Find a piece of paper material with a certain thickness and lay it on the ground. Hammer the barrel up and down several times to squeeze out the bubbles in the barrel. Find a piece of paper material with a certain thickness and lay it on the ground. Hammer the barrel up and down several times to squeeze out the bubbles in the barrel.

找一张有一定厚度的纸质材料铺在地上，上下捶打料筒几次，将料筒中的气泡挤出。



Install the clay charging cylinder onto the transmission
将装好陶泥的料筒安装到变速器上



Tighten the barrel clockwise
顺时针拧紧料筒



Install pc10-02 pneumatic joint on the barrel
安装PC10-02气动接头在料筒上



Tighten the pneumatic coupling with a wrench
使用扳手拧紧气动接头

8. Installing barrel holder

安装料筒固定支架



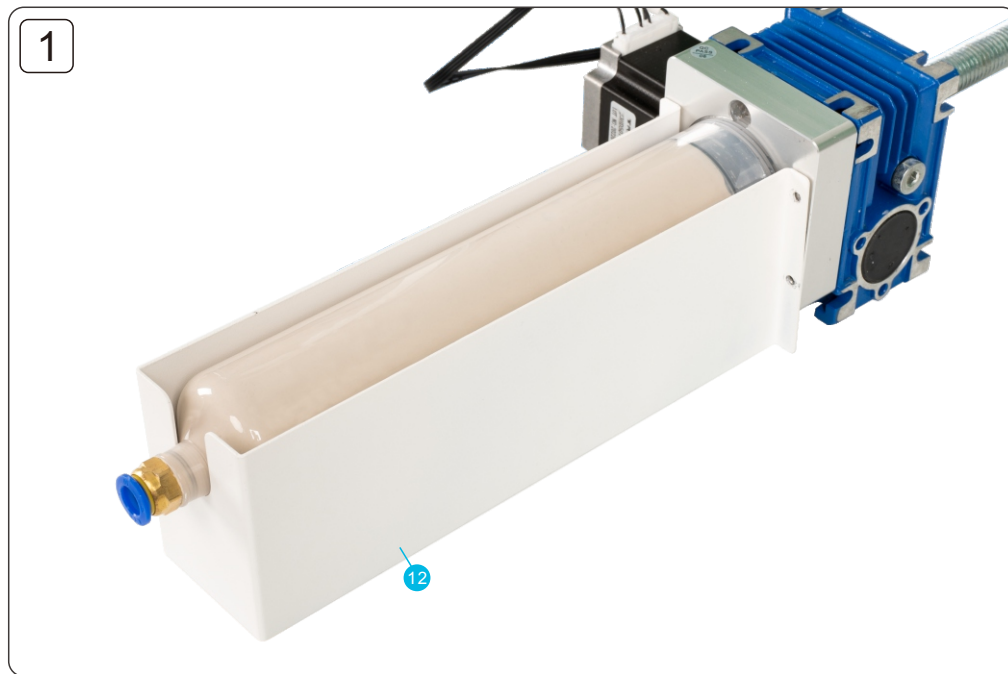
12

Barrel holder *1
料筒固定支架 *1



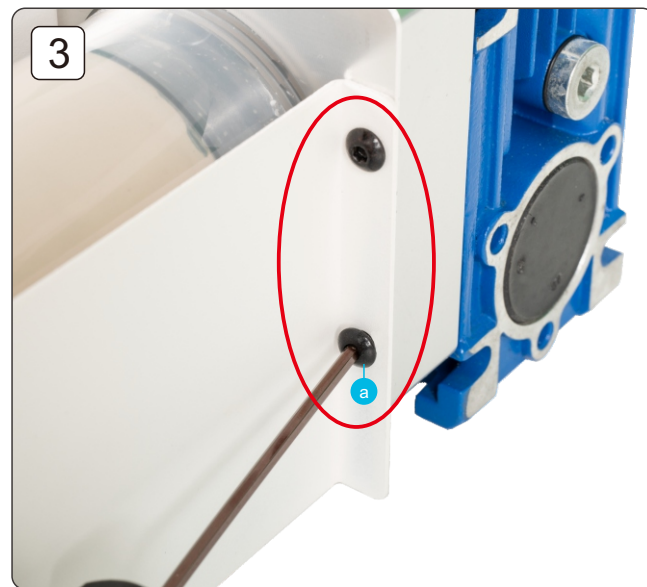
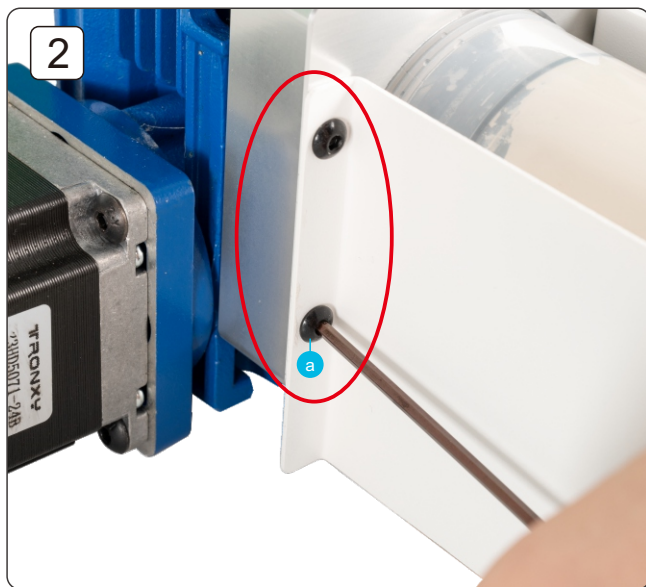
a

M4*10 screws *4
M4*10螺丝*4



As shown in the figure, place the barrel on the barrel holder

如图所示，将料筒放在料筒固定支架上

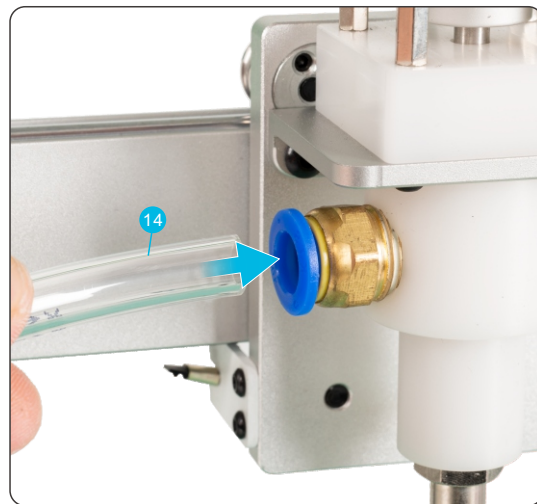


Use 4 M4*10 screws to fix the barrel holder
使用4颗M4*10螺丝固定料筒固定支架

9. Install tube 安装料管

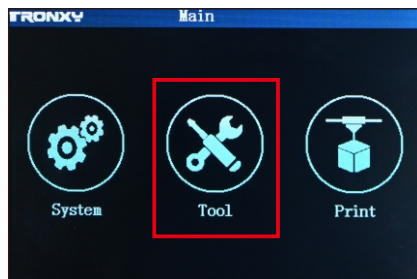


14
Tube *1
料管*1

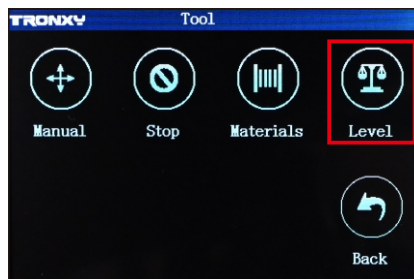


Insert the tube, and the machine installation is completed
插入料管, 机器安装完成

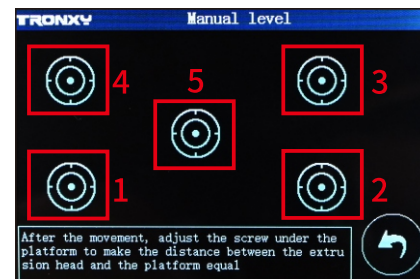
Platform leveling 平台调平



Select "Tool"
选择“工具”

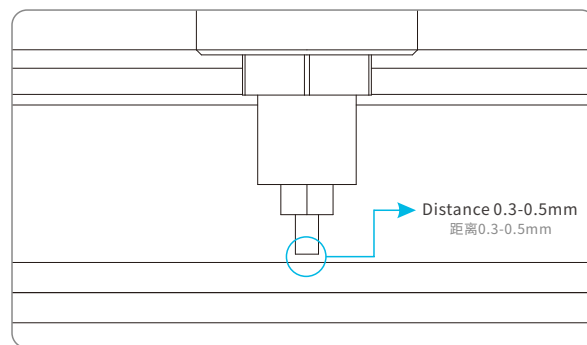
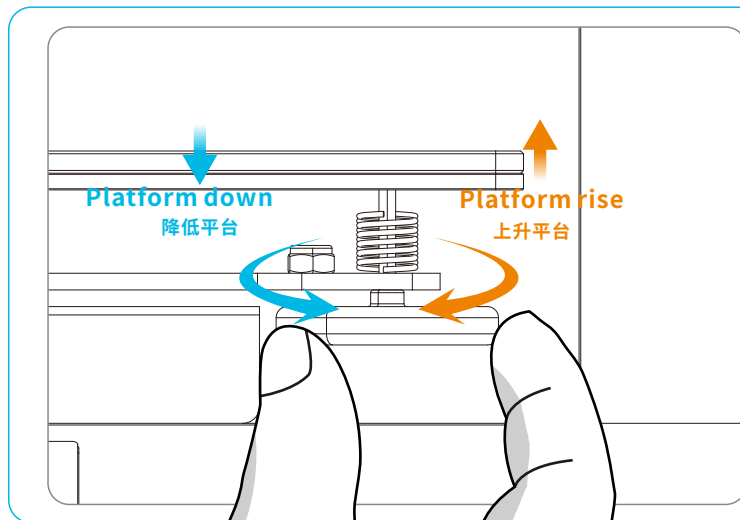


Select "Level"
选择“调平”



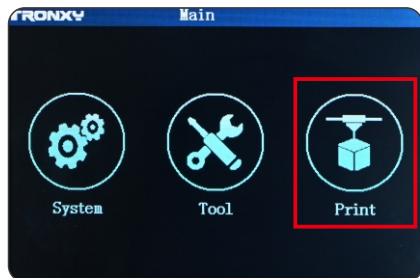
According to the sequence given in the figure, level the five positioning points one by one.
(Refer to the picture below for the leveling method)

按照图中给出的顺序，将五个定位点一一调平，最后点击返回。（调平方法参考下图）

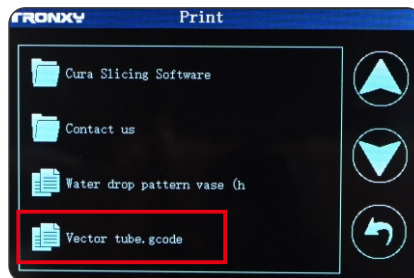


Adjust the four nuts under the platform to make the distance between the nozzle and the platform 0.3-0.5mm.

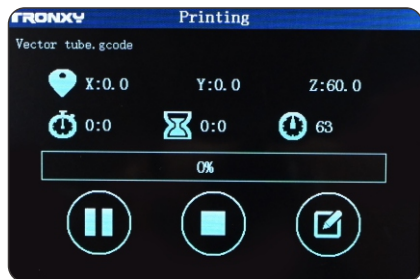
调节平台下方的四颗螺母，使喷嘴与平台的距离为0.3-0.5mm



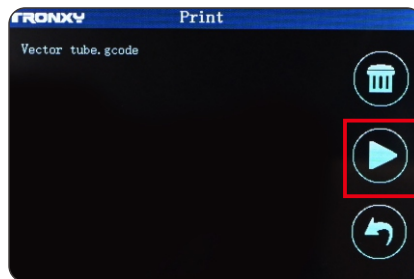
Select "Print"
选择“打印”



Select a file
选择一个文件



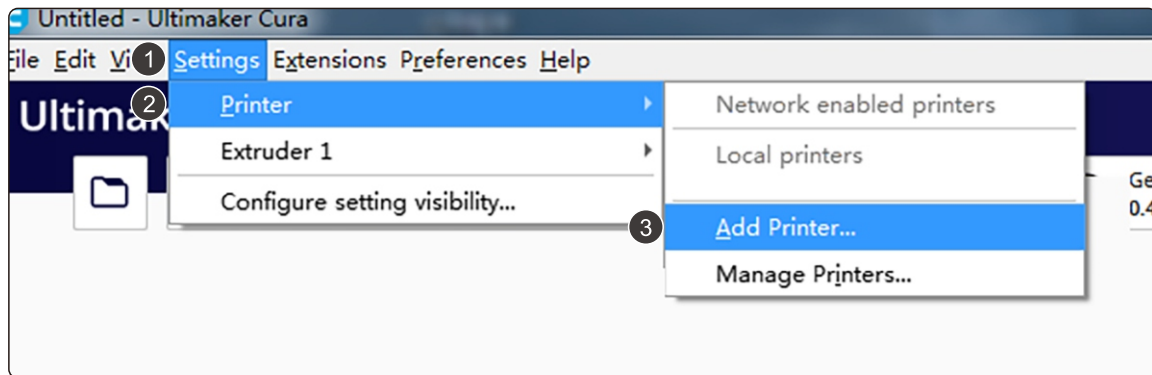
The machine enters the printing state
机器进入打印状态



Confirm to print the document and click the "start printing" icon
确认打印文件, 点击“开始打印”图标

Slice Software Installation Steps 切片软件安装设置

1. Install "Ultimaker_Cura-amd64" on the computer, double-click to install the software, and follow the prompts to complete the installation steps;
在电脑上安装“Ultimaker_Cura-amd64”，双击安装软件，按照提示完成安装步骤；
2. Add a printer;
添加打印机；

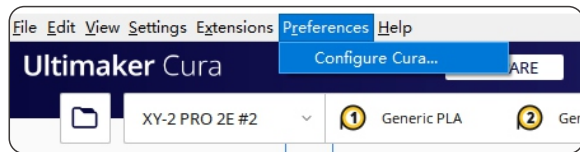


① Settings → ② Printer → ③ Add Printer...
设置 → 打印机 → 新增打印机

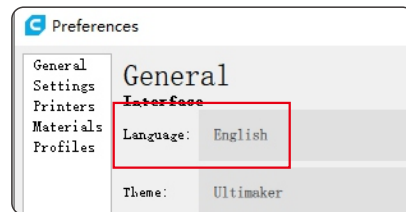


How to change the language of slicing software

切片软件如何更换语言

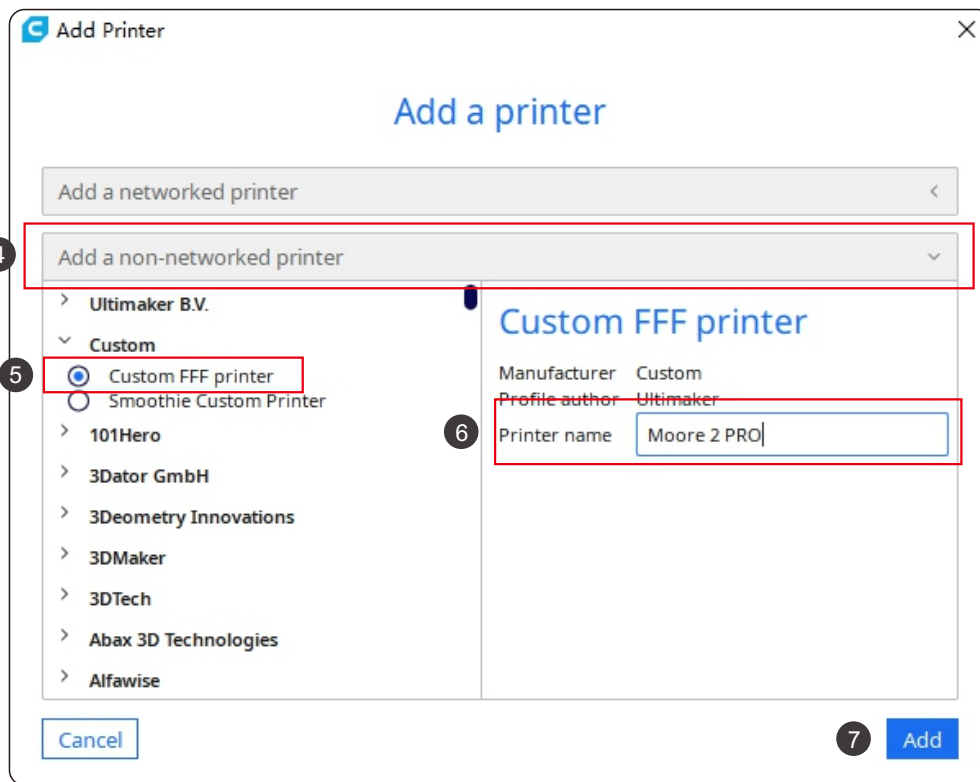


Preferences → Configure Cura...
偏好设置 → 配置Cura



After selecting the desired language, restart the software

选择好需要的语言后，后重启软件即可



- ④ Add a non-networked printer → ⑤ Custom FFFprinter → ⑥ Enter "Moore 2 PRO"
点击“添加未联网打印机” 选择“Custom FFFprinter” 输入“Moore2 PRO”
- ⑦ Add
点击“添加”

Slicing software settings 切片软件 的设置

Add Printer

Machine Settings

Moore 2 PRO

Printer

Extruder 1

Printer Settings

X (Width)

255.0mm

Y (Depth)

255.0mm

Z (Height)

260.0mm

Build plate shape

Rectangular

Origin at center☐

Heated bed☐

Heated build volume☐

G-code flavor

Marlin

Printhead Settings

X min

-20mm

Y min

-10mm

X max

10mm

Y max

10mm

Gantry Height

260.0mm

Number of Extruders

1

Apply Extruder offsets to GCode☒

Start G-code

G28 ;Home

End G-code

M104 S0

Next

Add Printer

Machine Settings

Moore 2 PRO

Printer

Extruder 1

Nozzle Settings

Nozzle size

1.5mm

Compatible material diameter

3.0mm

Nozzle offset X

0.0mm

Nozzle offset Y

0.0mm

Cooling Fan Number

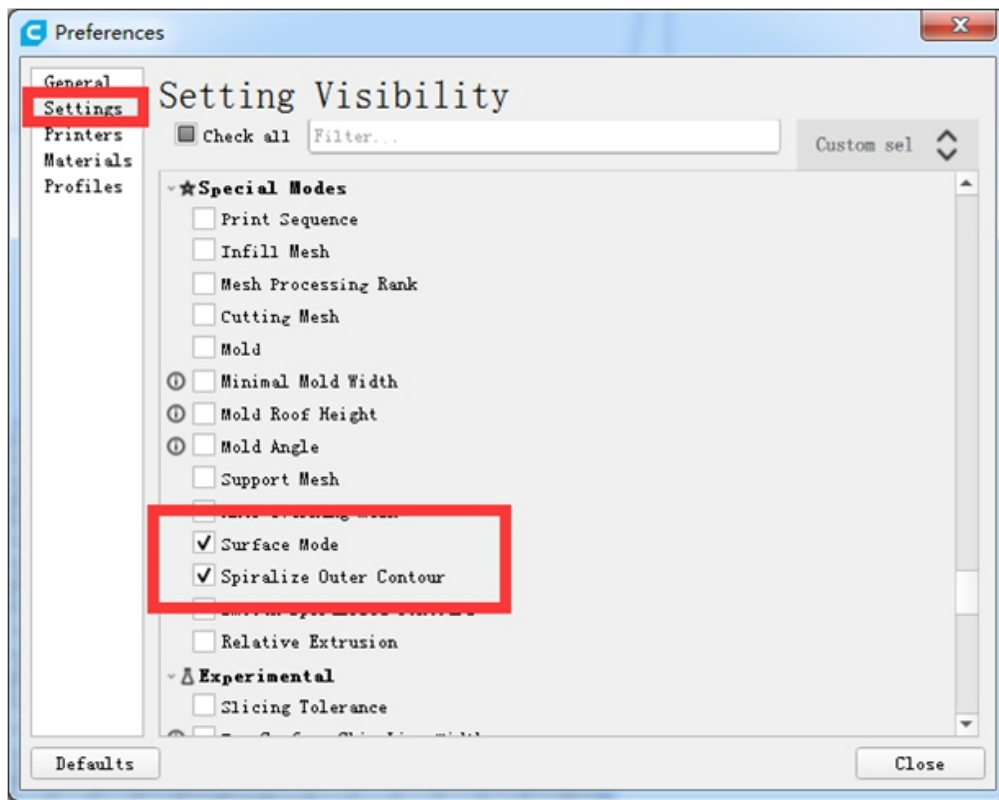
0

Extruder Start G-code

Extruder End G-code

Next

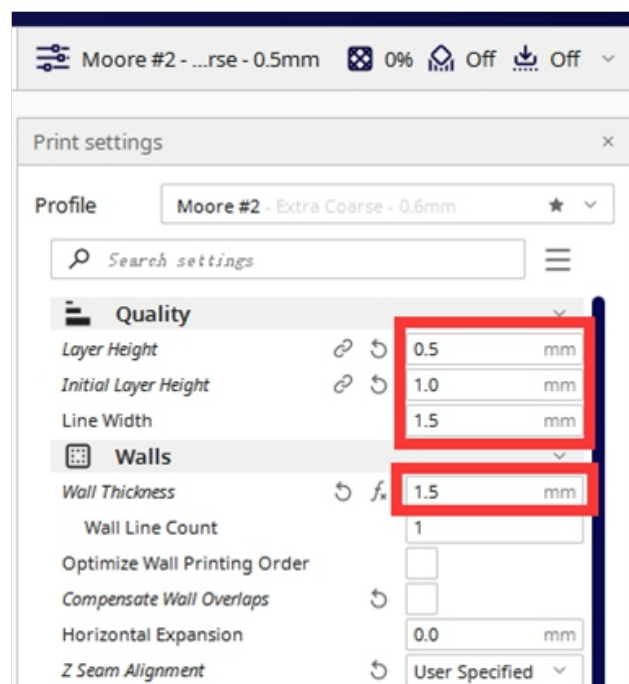
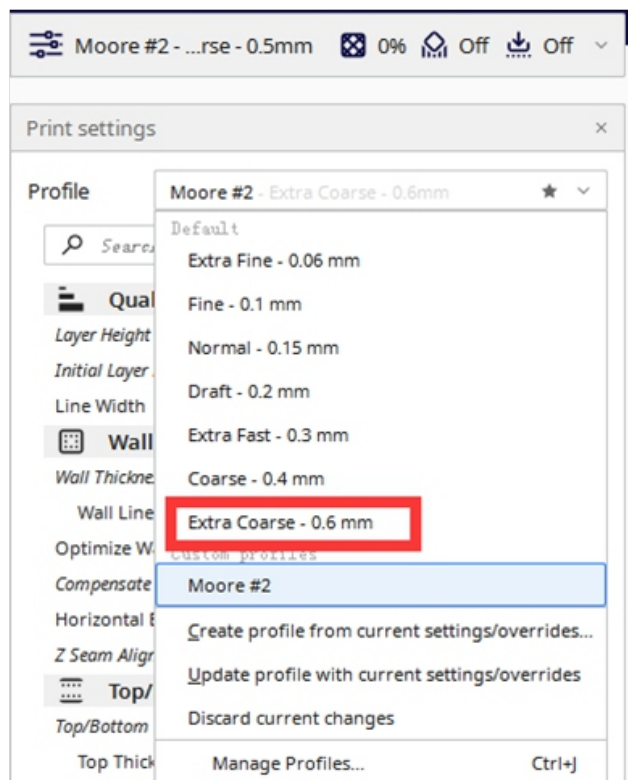
Set the value as shown in the figure
如图所示设置数值



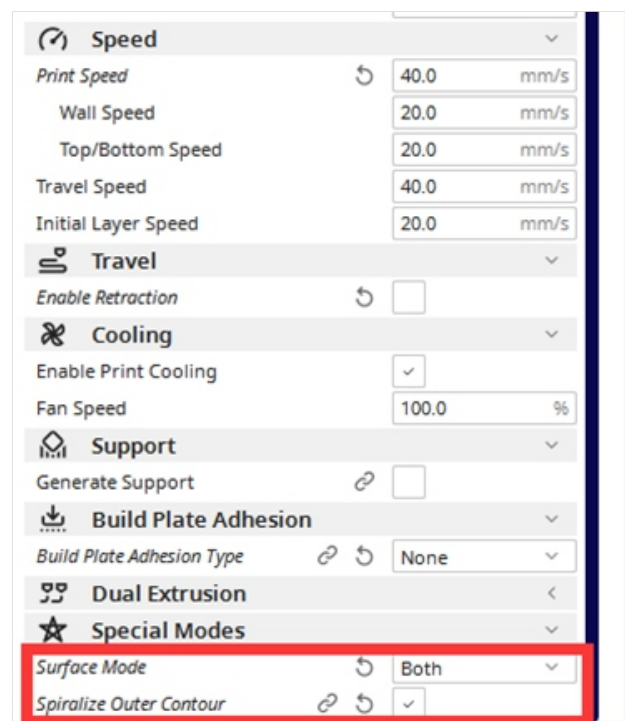
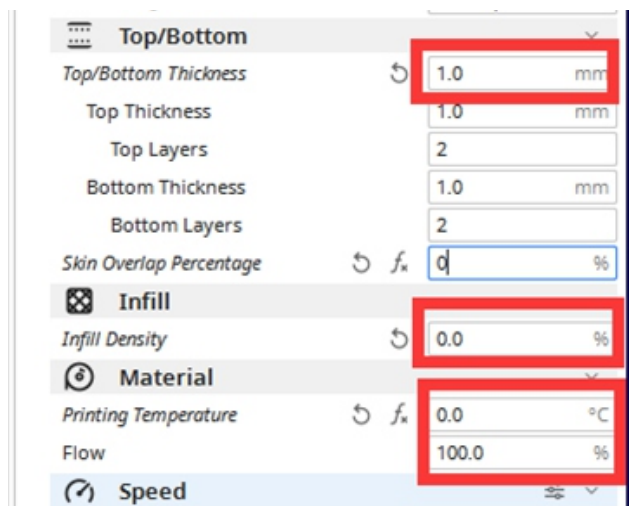
Select the option in the red circle

勾选红圈中的选项

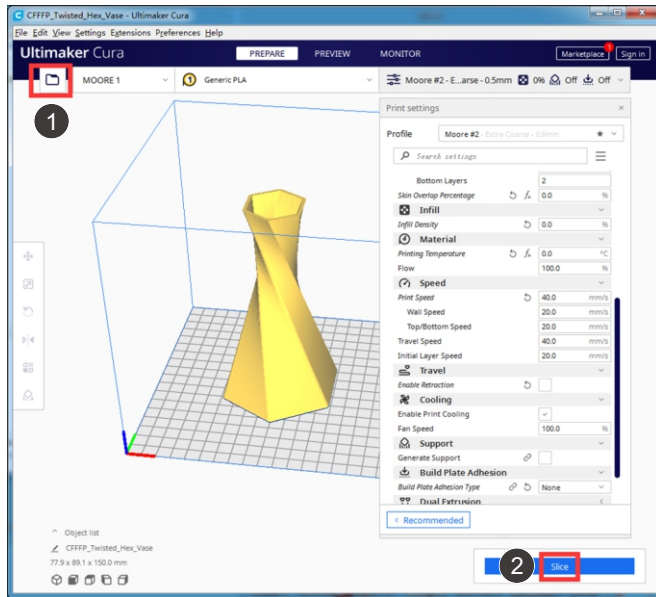
2. parameter settings 参数设置



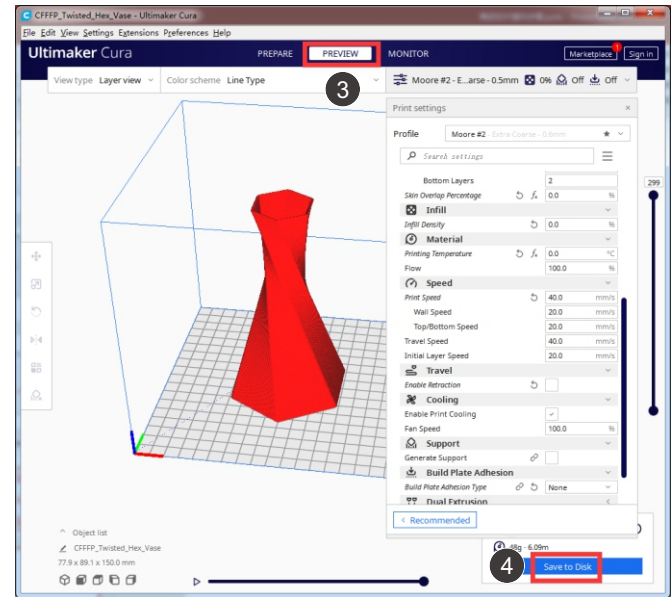
Slicing software settings 切片软件的设置



Slicing software settings 切片软件 的设置



① Open a file → ② Slice
打开一个文件 切片

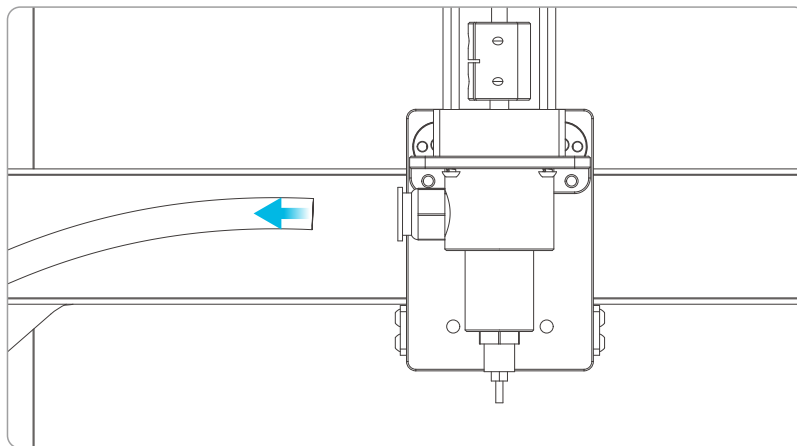
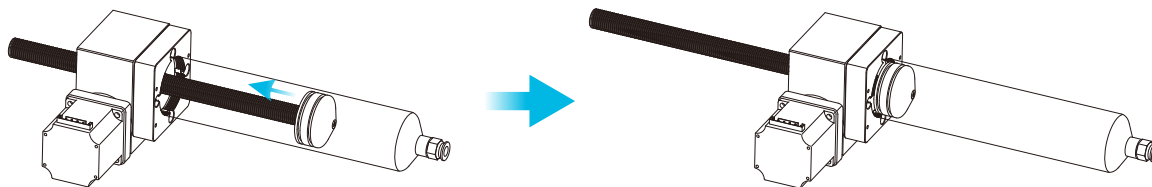


③ Preview → ④ Save to Disk
预览 保存到磁盘

Precautions and operations for replacing the barrel 更换料筒的注意事项与操作



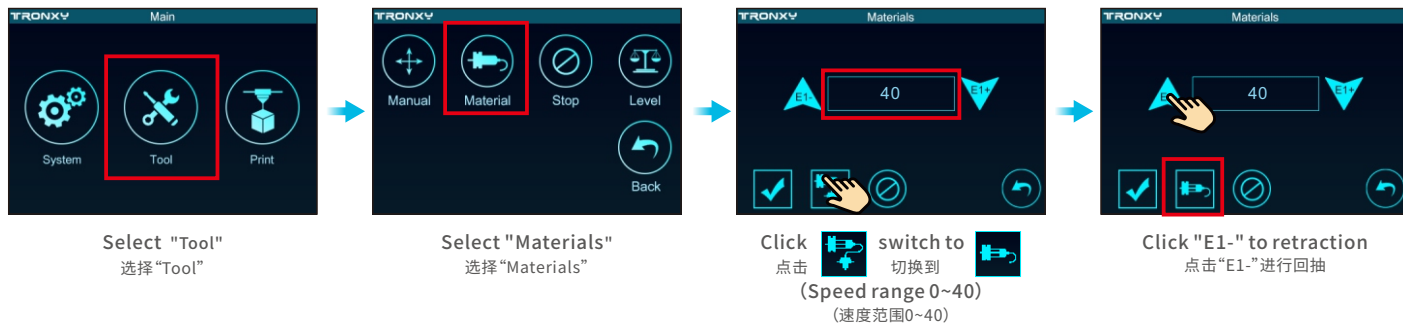
The piston must be moved to its original position before changing the barrel.
更换料筒前，必须将活塞移动到初始位置。



The feed tube of the print head must be unplugged before operation.

操作之前必须拔下打印头的进料管

Precautions and operations for replacing the barrel 更换料筒的注意事项与操作



Three control methods of Materials

耗材的三种控制方式



Linkage mode (default)

Can control the feeding device and the motor of the print head at the same time.

联动模式(默认)

可以同时控制送料装置与打印头的电机。



Feeding device mode

Separately control the motor of the feeding device.

送料装置模式

单独控制送料装置的电机。

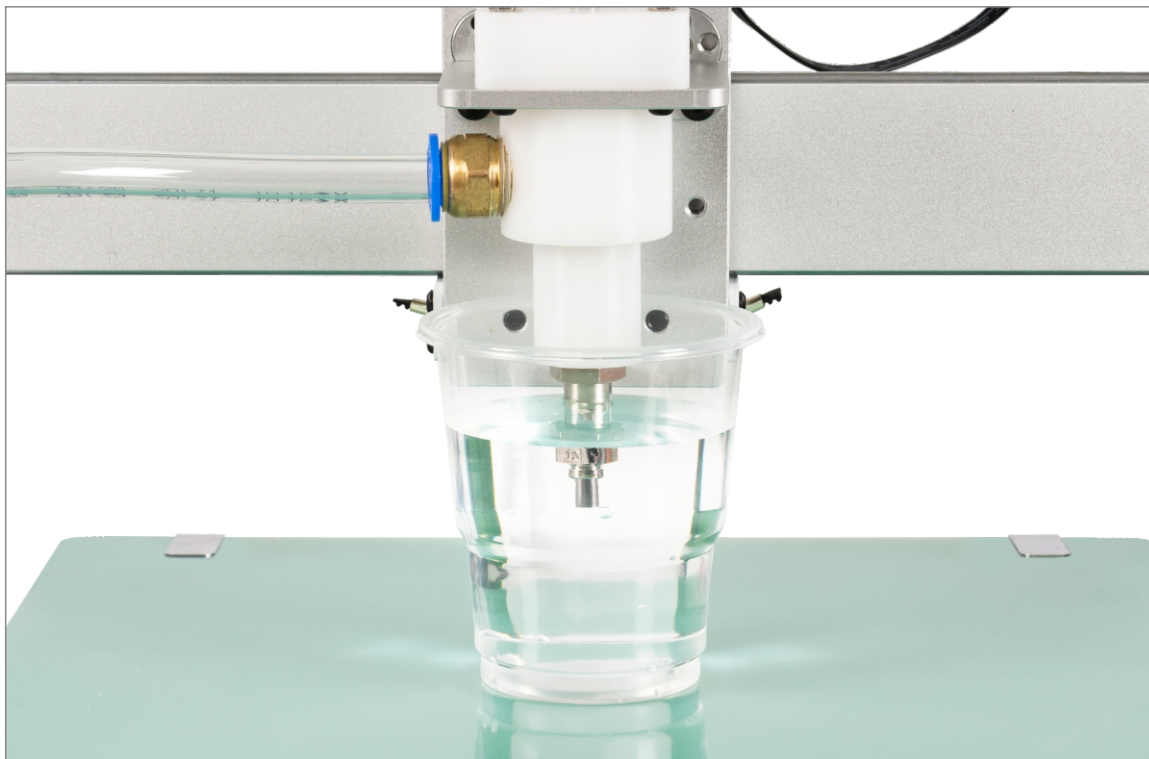


Print head mode

Separately control the motor of the print head.

打印头模式

单独控制打印头的电机。



Note: soak the printhead/nozzle in the water after printing to prevent the mud from drying and clogging the printhead

注意:打印完将喷嘴浸泡在水中以防泥料干掉

Due to the differences between different machine models, the physical objects and the final images can differ.

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